









**Work Order ID 69518**

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Wednesday, May 11, 2011 2:46:06 PM

Item ID: D4021-1 Accept  Setup Start   
Revision ID: Stop   
Item Name: Handle Plate  
Start Date: 5/11/2011 Start Qty: 9.00  Cust Item ID:  
Required Date: 5/16/2011 Req'd Qty: 9.00  Customer:  
Reference:

Approvals: Process Plan:  Date: 11-05-11 Tooling: Date: Run Start   
QC: Date: SPC (Y/N): Date: Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4021	B								

100		0.00							
									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg D4021								
304 .125	Prog Rev: B								
	Dwg Rev: B								
	Deburr as required								

B11-5-16

(16)

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

B11-5-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69518**

Wednesday, May 11, 2011 2:46:06 PM

Page 2

Item ID: D4021-1

Accept

Revision ID:

Item Name: Handle Plate

Start Date: 5/11/2011 Start Qty: 9.00

Required Date: 5/16/2011 Req'd Qty: 9.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/11/05/16

(16)

140



Packaging

Packaging

Identify as per dwg &amp; Stock Location: WA

0.00

0.00

Memo

SAD 11-05-19

(16)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/19  
MK  
11-05-19

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 11, 2011 2:46:13 PM

Page 1

Work Order ID: 69518

Parent Item: D4021-1

Parent Item Name: Handle Plate





Start Date: 5/11/2011

Required Date: 5/16/2011

Start Qty: 9.00

Required Qty: 9.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as  
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB  
DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  304/316 0.125 Sheet		Purchased	No			100	sf	157.9000	0.1225 	1.160526	2. B11-5-16		
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT020		157.9							
				117494		157.9							
								107494					

16

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Dart Aerospace Ltd

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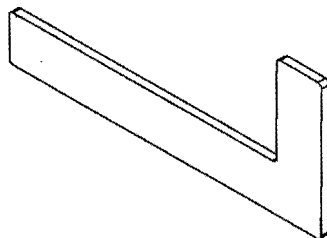
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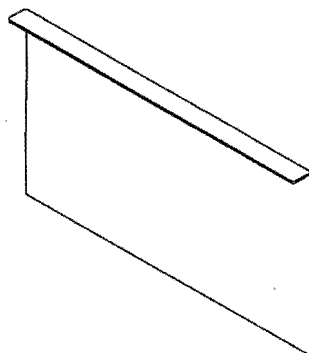
**NOTE:** Date & initial all entries



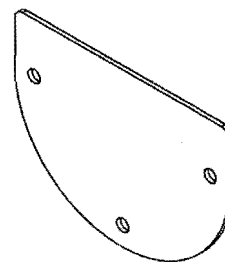
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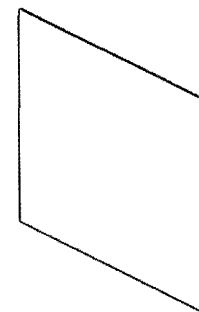
D4021-1 HANDLE PLATE



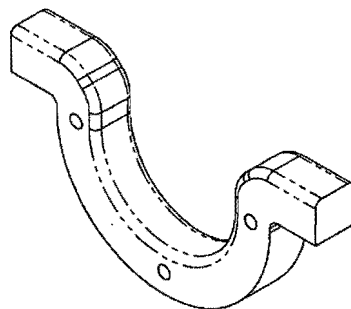
D4021-3 DATA PLATE



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



D4021-9 BUSHING

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69518  
R811-05-11

RELEASED  
2010-04-14  
MP

B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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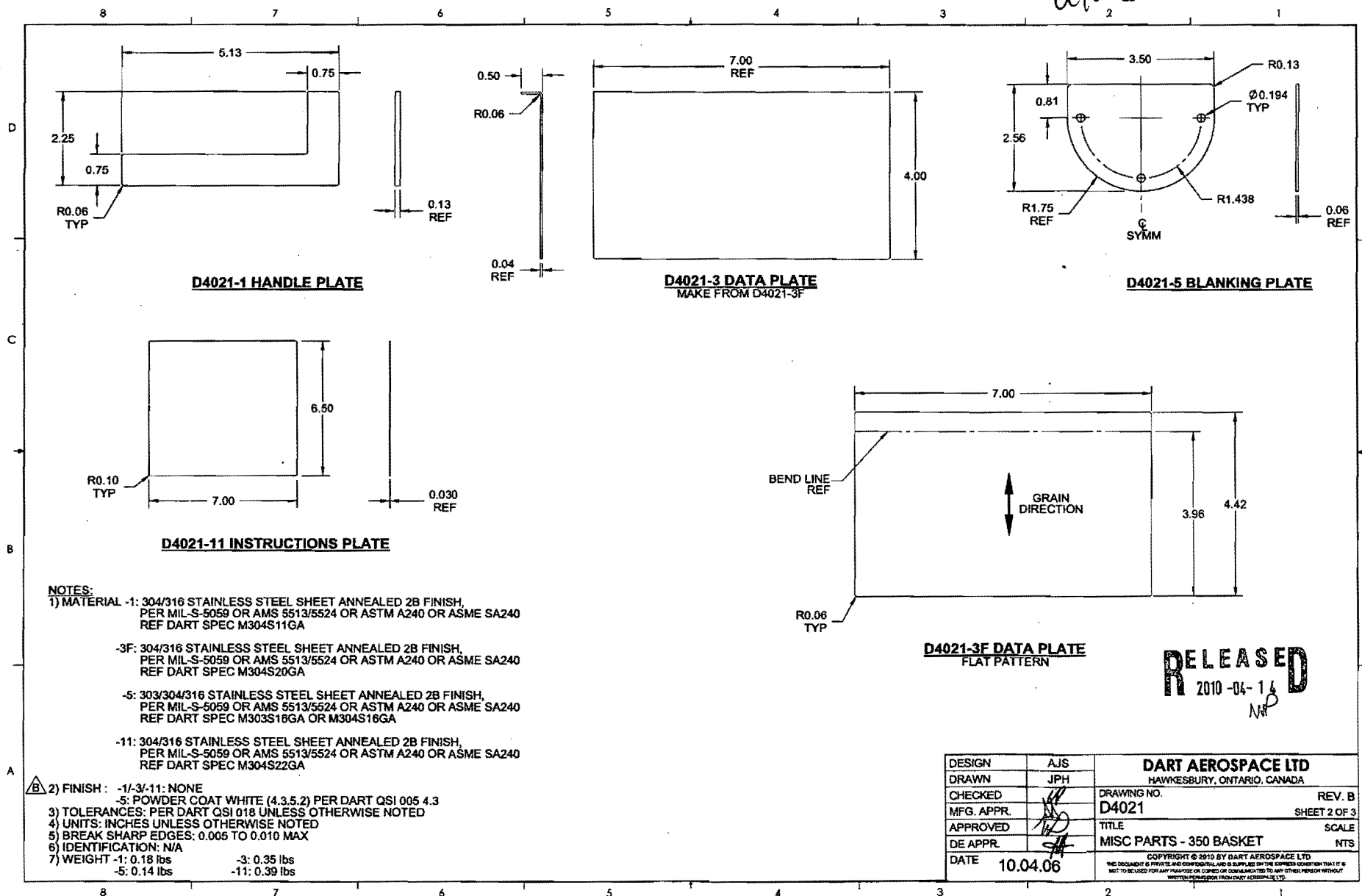
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**NOTE:** Date & initial all entries

u/b 69578



DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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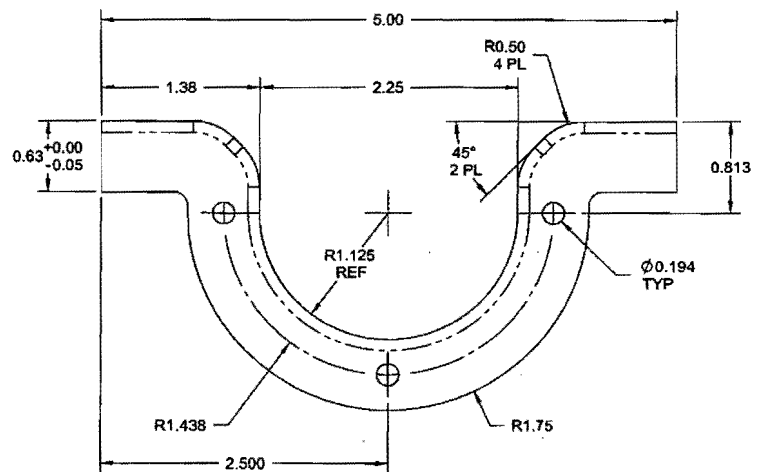
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

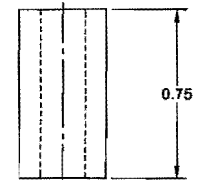
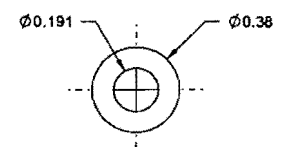
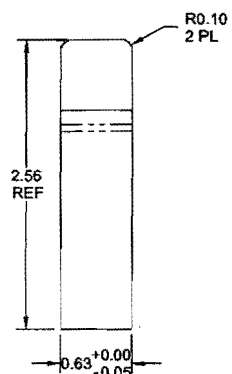
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W/O 69518



**D4021-7 HOOP**



**D4021-9 BUSHING**

**NOTES:**

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276  
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs  
-9: 0.02 lbs

**RELEASED**  
2010-04-14  
NR

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
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DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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